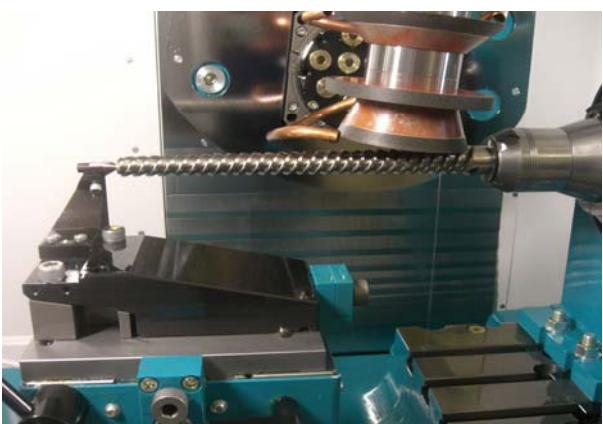


Tapered Reamer Ø22 Z3 high helix

A15-010

Long tapered reamers with steep negative helix can not only be easily resharpened but also manufactured. In order to obtain the requested rake angle, the flute face is ground with the periphery of a 1V1 wheel. This cinematical approach allows to grind those long tools with negative helix on a compact machine - as the GEMINI DMR is - without any limitations, usage of tailstock included.



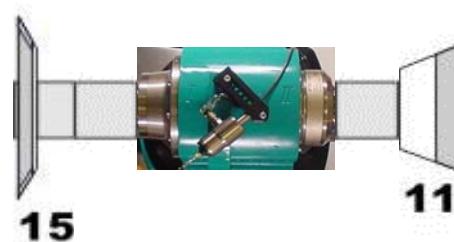
1. Cycletime for Production

Tool specifications			
\varnothing 22 mm, Z 3, L 265 mm, Helix 62°, Taper 0.57°			
Material HSS			
Operations	Probe	Flute 1	O.D.1
Feed [mm/Min]	2000	75	300
Power [kW]		4	1
Cutting feed [m/s]		32	32
Used wheels		15	11
Grinding time [s]	50	1419	361
Total cycle time	30 Min 29		

The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

2. Used Grinding Wheels

15	1V1 Ø125 B126
11	11V9 Ø100 B126



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : GEMINI DMR, manual or hydraulic Tailstock
Control: Fanuc 31i
Coolant: Synthetic Oil, pressure 6 bar
Software: Quinto 5

responsible engineer: OP,6.4.09

www.schneeberger.ch

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